

Finish Date: Fri, December 23, 2016

Due Date: Mon, January 16, 2017

Shop Copy

Order No: 6666	Customer No: 546	Product Code: ROLLERS
Quote No:	Purchase Order No: 40911	Priority: 50
Novat Part No: 81131	Customer Part No: 1126	Ship Via: USF / HOLLAND

Description: 4.375"CD X 6.5"OD X 1.5"FACE MILL #1 & #2 PULLER ROLL
95/100A SAFETY ORANGE
RECOVER
OVERCAST/MACHINE BY NOVATHANE

Mold Number: 546 - 81131

Mold Weight

Qty To Order: 5

Qty To Stock: 0

Total Qty Open: 5 EA (see set-up for mold instructions)

Qty To Make: 5

Formula

NCO 5.36

Formulated 11/9/2015 5:03:35 AM

Hardness: 90A

Material	Wt.	%
9-5APLF	771	70.6
SANTICIZER 160	193	17.7
CURENE 442	125	11.4
DR-62280 SAFETY ORANGE	3.2	0.29

Parts Per Pour	2.00
# of Buckets	1.00
Estimated Weight	1.20 (LB)
Volume	47.00 (CU IN)

Routing

Step No	Operation	Description
10	STRIPPING	Strip Old Material
20	BLAST	Blast OD
30	PREP	Clean and Apply Chemlok 213
40	SET-UP	Set Up 6.5"ID Tubes — Parts Must Be Centered
50	CASTING	Parts Must Be Centered In Molds
60	MACHINING	Machine Corner 1/4" Radius

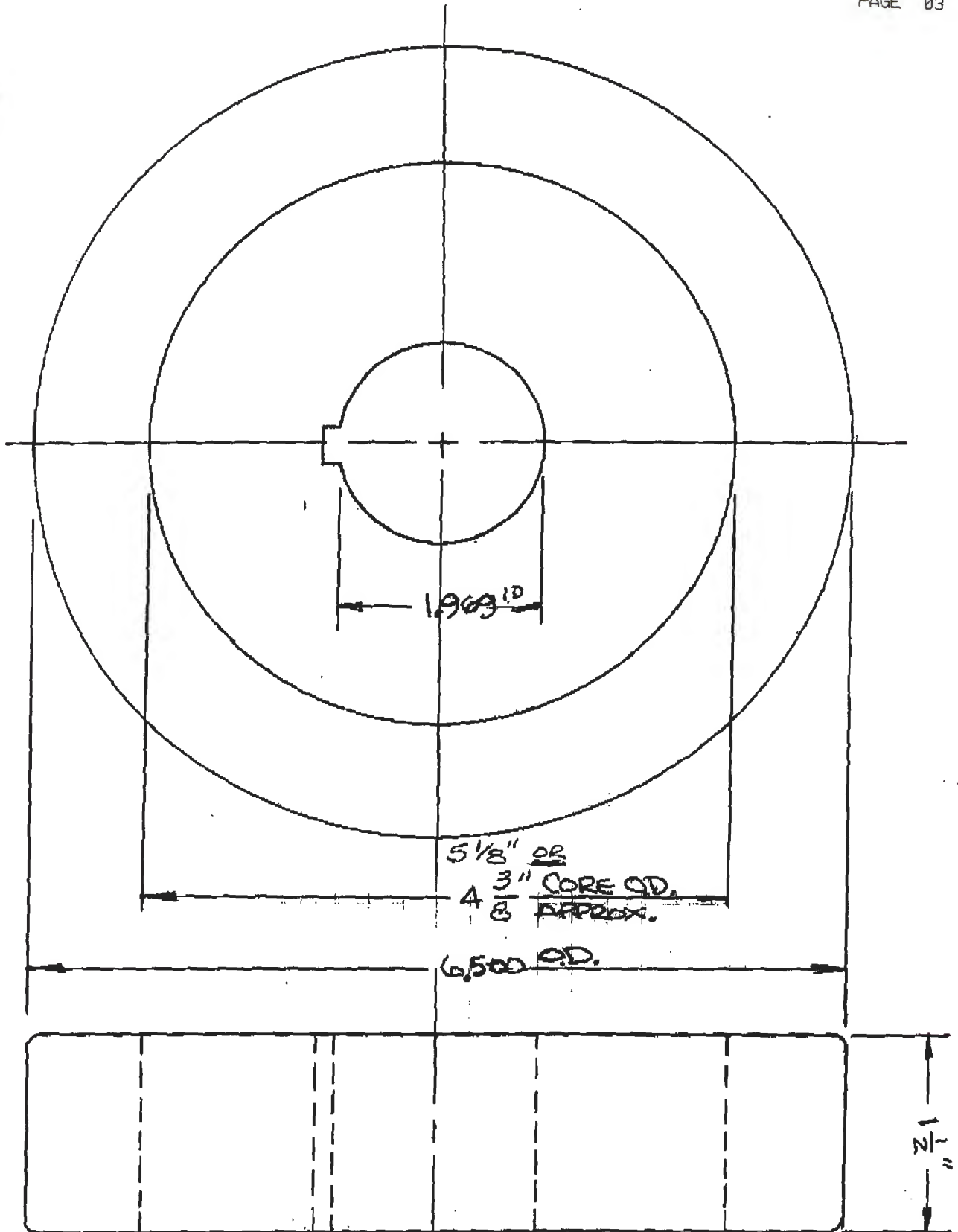
Time per Piece (HR):	.20	.67	.87	1.50
Total Time for Job (HR):	1.00	3.33	4.33	

MATERIAL ~ 95A ORANGE ADIPRENE LIGMOC A CURED POLYURETHANE

MIL 1 1/2 RUBBER ROLL

HKB DUG NO 1126

BREAK



HKB ENTERPRISES, INC.